

Work Order ID 46680

Thursday, June 10, 2010 8:55:34 AM



See other w/c mr

Page 1

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly RH

Stop



Start Date: 12/16/2009 Start Qty: 1.00



Required Date: 12/18/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2991	D								
IIN-D350-589	E								
100	DOCUMENT CONTROL	0.00							
DC									
Document Control	Memo	0.00							
	Photocopy bluefile & type labels per PPP D350-589-042/ DSI 9463								
	CHG005								
110	Pick Kit	0.00							
Packaging									
Packaging	Memo	0.00							

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 46680

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Page 2

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 12/16/2009 Start Qty: 1.00



Required Date: 12/18/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg



150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



160



Packaging

Pick Kit

0.00

Memo

0.00



W/O:			WORK ORDER CHANGES					
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 46680

Thursday, June 10, 2010 8:55:34 AM

Page 3

Item ID: D350-589-042

Accept

Revision ID:

Item Name: Side Door Assembly RH

Start Date: 12/16/2009 Start Qty: 1.00

Required Date: 12/18/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

180

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-589-042/ DSI 9463

Location:

PPP rev:

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 9:46:58 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D350-589-042

Job Number : 46680

Estimate Number : 10804

P.O. Number :

Part Number : D350589042

This Issue : 25/03/2009

S.O. No. :

Drawing Number : REWORK

Prsht Rev. : NC

Project Number :

First Issue : / /

Type : SMALL / MED FAB

Drawing Revision :

Previous Run : 46674

Material :

Due Date : 31/03/2009

Qty: 1 Um: Each



Written By :

Checked & Approved By :

Comment :

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

PULL FROM STOCK:

1 X D2991-2 B111160

REMOVE EXISTING DOUBLERS D2992-1

RT 10-06-08

2.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S10/06/08

3.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

BOND NEW DOUBLERS D2992-1 REV.B

AS PER DRWG D2991-1

PROCEED TO ASSEMBLE PER BELOW

PTO

4.0

D29912

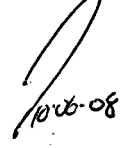
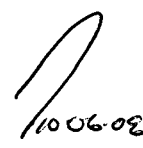
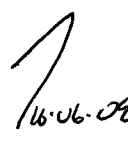
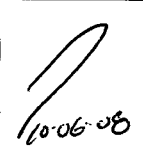
Side Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Side Door

W/O: 46680

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-12-10	3.0	Pull doublers from stock D2992-1 B 47743 and install on door D350-589-042	ET	10-06-08		 10.06.08	 10.06.08
		used cloth FG 778150-550 ROL B 111166 epoxyst 956 112935	ET	10-06-08		 16.06.08	 10.06.08

Part No: D350-589-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 9:46:58 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-042

Job Number: 46680

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2464-1700	Foam seal	48173

RT 10-06-08

6.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2585	Latch clamp	56524

RT 10-06-08

7.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2586	Door latch	55314 ² 57917 ¹

RT 10-06-08

8.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2621	latch plate	46842

RT 10-06-08

9.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	47687

RT 10-06-08

10.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS21042L3	Nut	114523 ⁸³

RT 10-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/06/06							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-042

Job Number: 46680

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description

Batch

3 AN960JD10 Washer

114292

ET 10-06-08

12.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description

Batch

3 MS27039-1-15 Screw

114056

ET 10-06-08

13.0

D37211

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: 45492

ET 10-06-08

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

ET 10-06-08

15.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP
EFFECTIVE 10-05-08 AUTH UP
RELEASED 2 DATE 006-08

Sidelobes + tests in helicopter Fits OK

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

17.0

D38941

Switch Plate



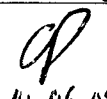
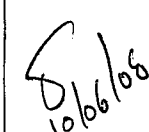

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch: 346896

10-6-9

5f

W/O: 46680		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.05.28	13	INSTALL AFT LATCH @ 2.5° FROM BOTTOM EDGE. GET ENG APPROVAL / TEST INSTALL	ET	10-06-08		 10.06.08 PS 042	 10/06/08	
000604	14	prime & paint Doors as per QSR 005 use filler on inside as necessary B113054	ET	10-06-09			 10/06/09	

Part No: D350-589-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: Wednesday, 25/03/2009 9:46:58 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-042

Job Number: 46680

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch: B 52964

10-6-9 sl

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description Batch
3 D2237 Striker Plate B57255

10-6-9 sl

20.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch
1 D2589 keys, key chain B58194

10-6-9 sl

21.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description Batch
6 AN3-4A Bolt M104817

10-6-9 sl

22.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description Batch
6 MS20470AD4-5 Rivet M114718

10-6-9 sl

23.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

M114523 10-6-8 sl

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 9:46:58 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-589-042

Job Number: 46680

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sublot 01 to @ C5C7005

25.0

PACKAGING 1

PACKAGING RESOURCE #1



P/W H for BG 6/06/08 @



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *112*

REC E

10-6-98

26.0

QC21

FINAL INSPECTION/W/O RELEASE



10/06/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
10-6-28

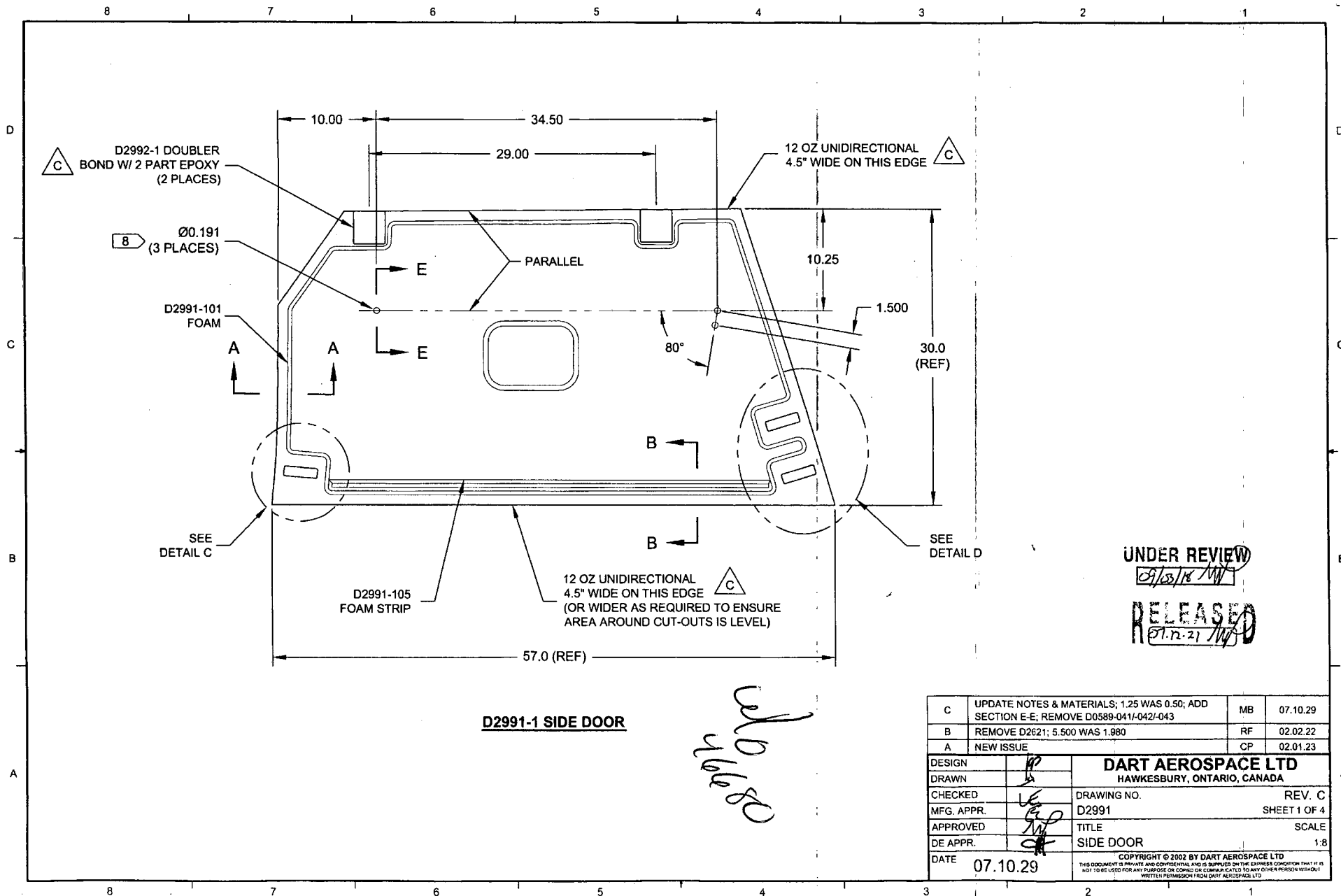
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



UNDER REVIEW
 09/13/18 MW
 RELEASED
 01.12.21 MW

C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

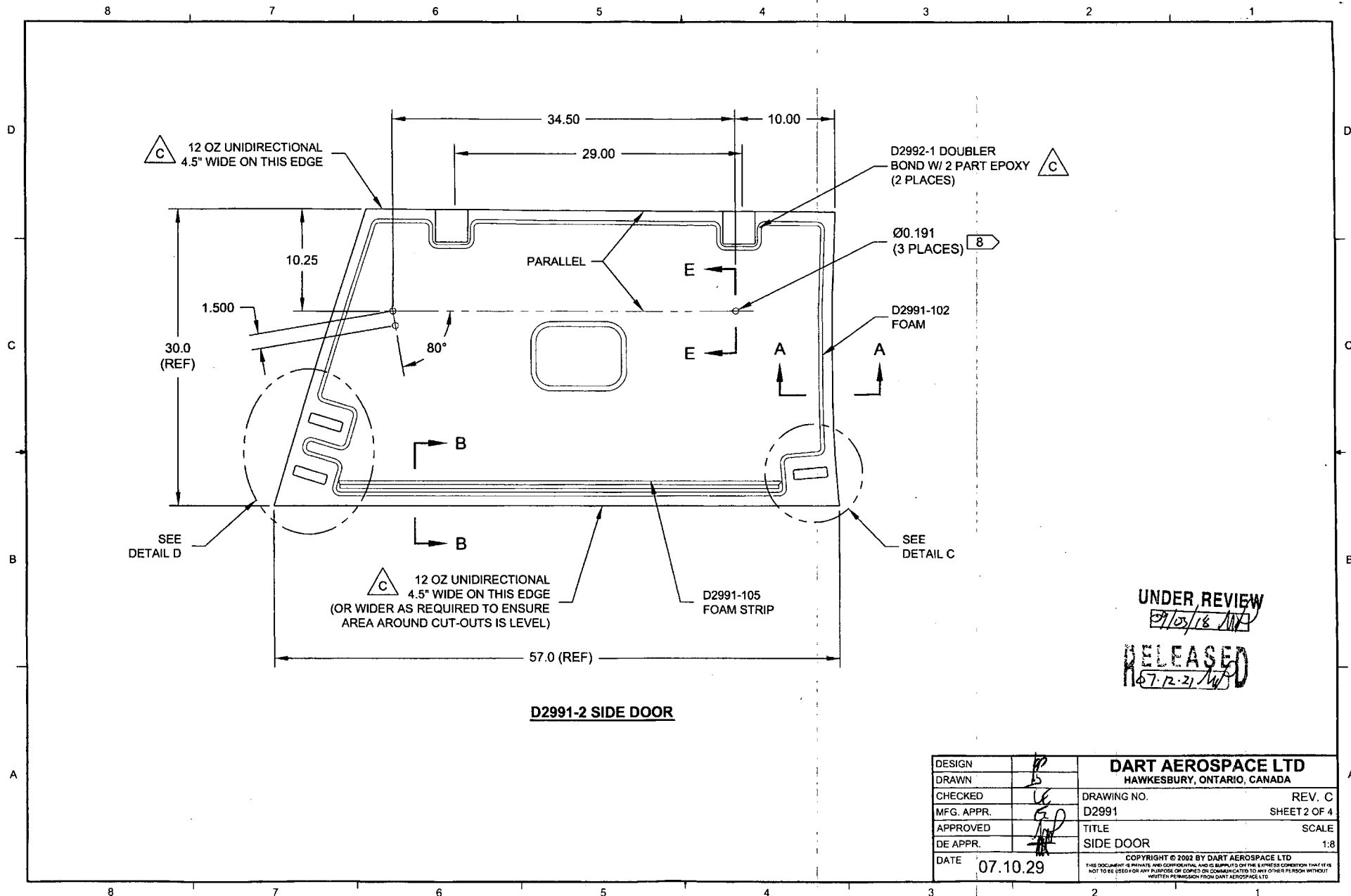
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



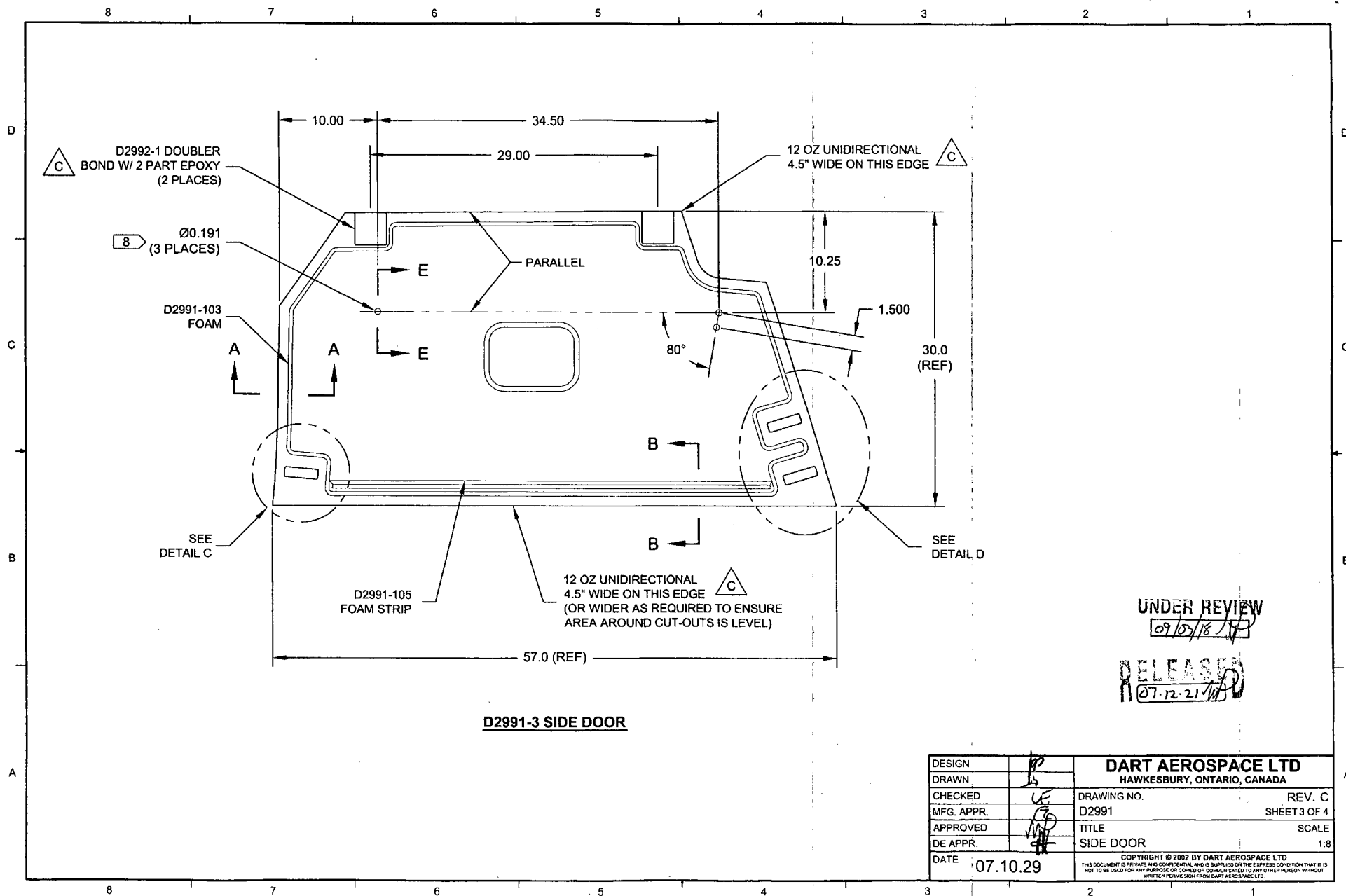
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

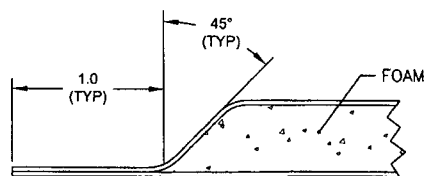
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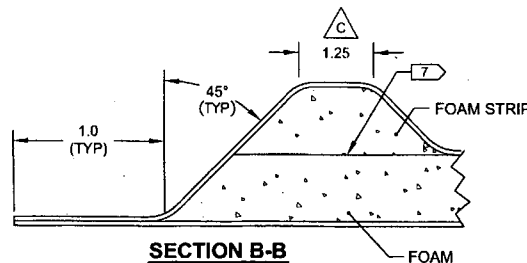
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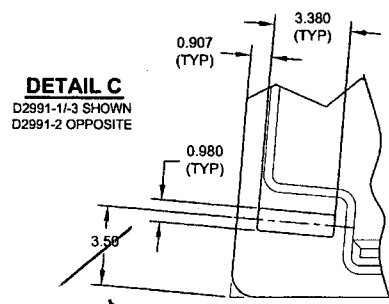




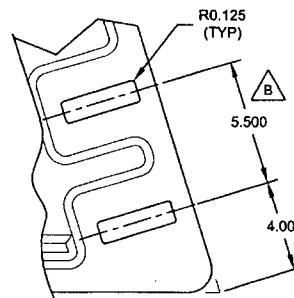
SECTION A-A
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



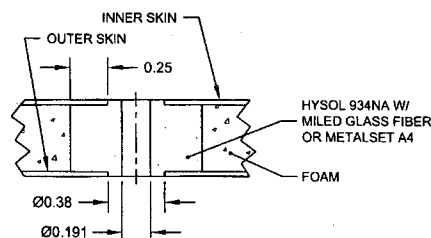
SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL C
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL D
D2991-1/3 SHOWN
D2991-2 OPPOSITE









SECTION E-E
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/2-3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/2-3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

UNDER REVIEW
07/03/18

RELEASED
07-12-21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:5
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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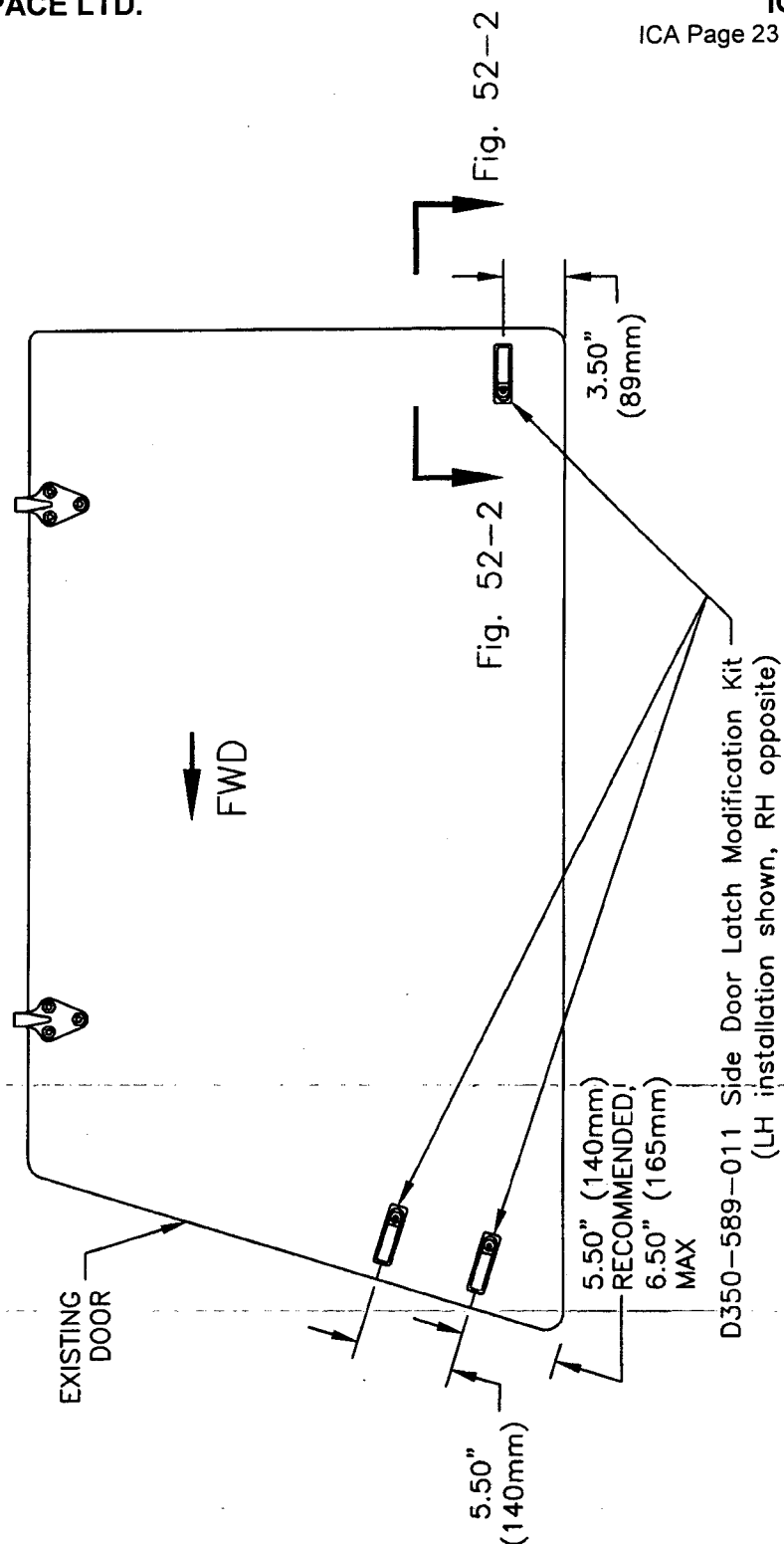


Figure 52-1: Typical D350-589-011 Side Door Latch Modification Kit

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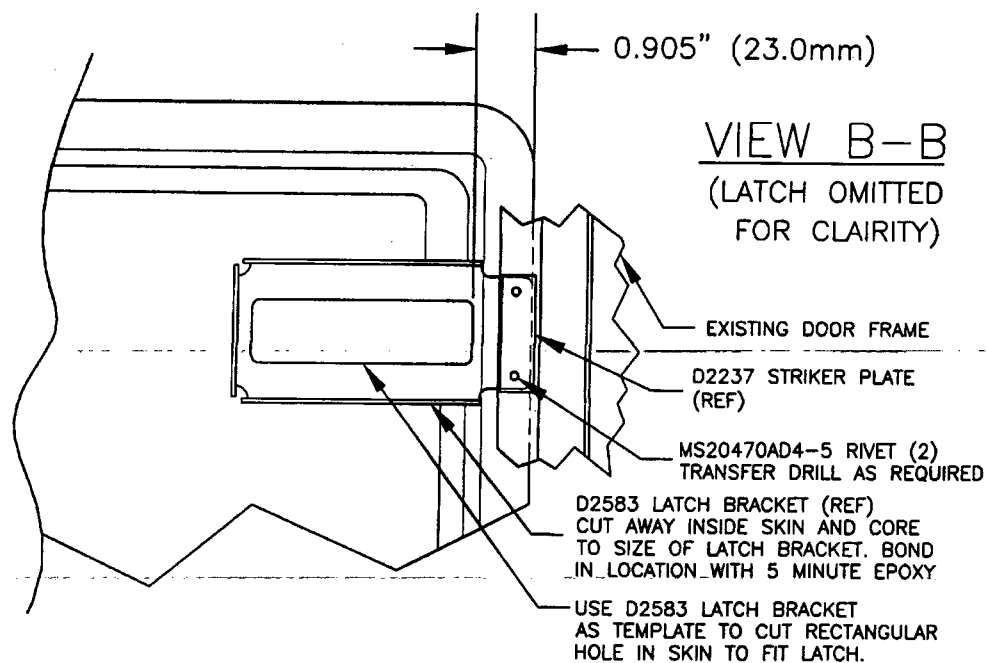
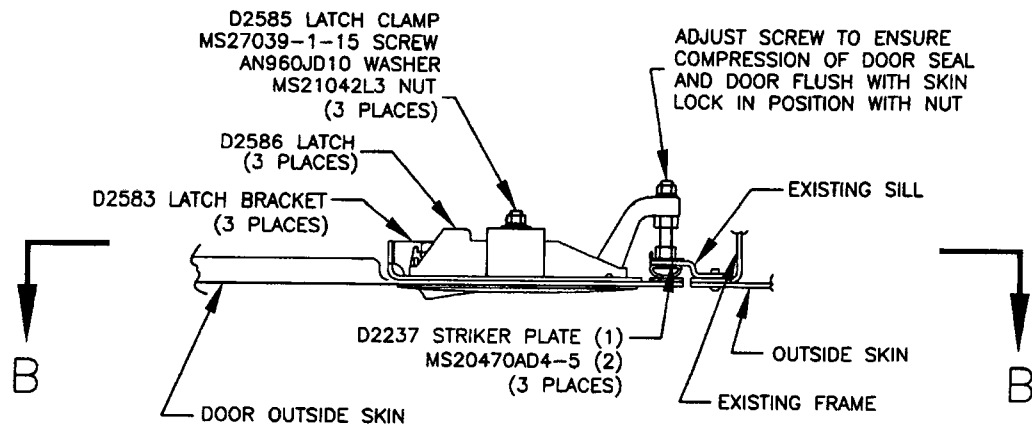


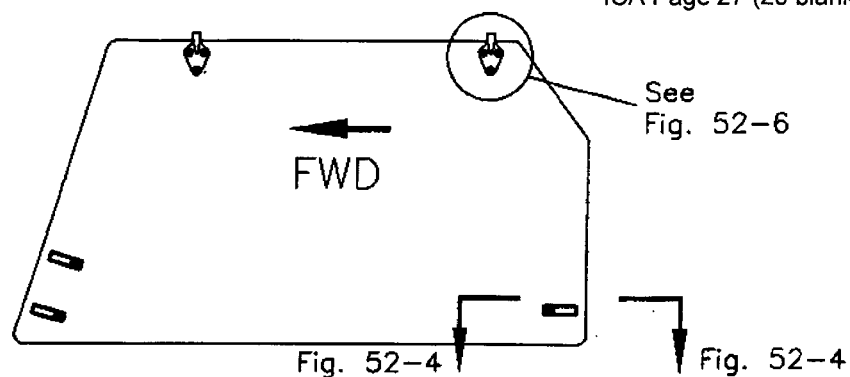
Figure 52-2: Typical Latch Bracket Installation

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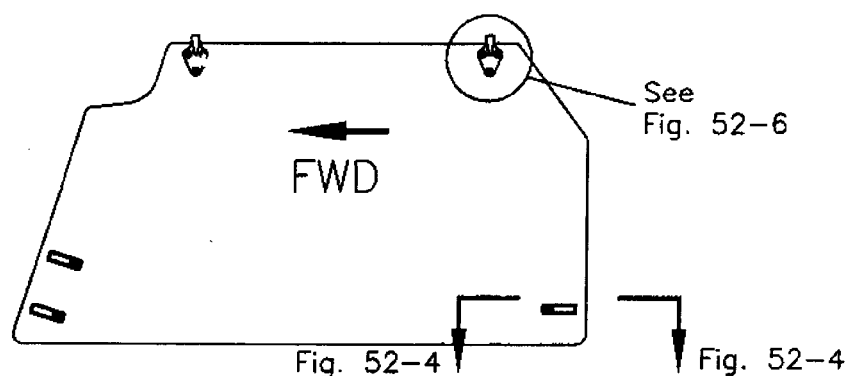
52-00-00

Revision: 0

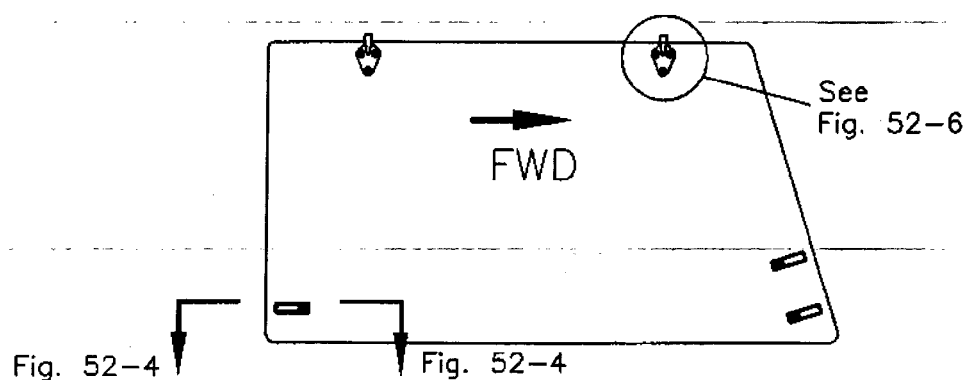
Page 5 (6 blank) of 18



D350-589-041 SIDE DOOR ASSEMBLY, LH AS 350



D355-589-043 SIDE DOOR ASSEMBLY, LH AS 355



D350-589-042 SIDE DOOR ASSEMBLY, RH AS 350/355

Figure 52-3: D350-589-041/-042 and D355-589-043 Side Door Assemblies

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52-00-00

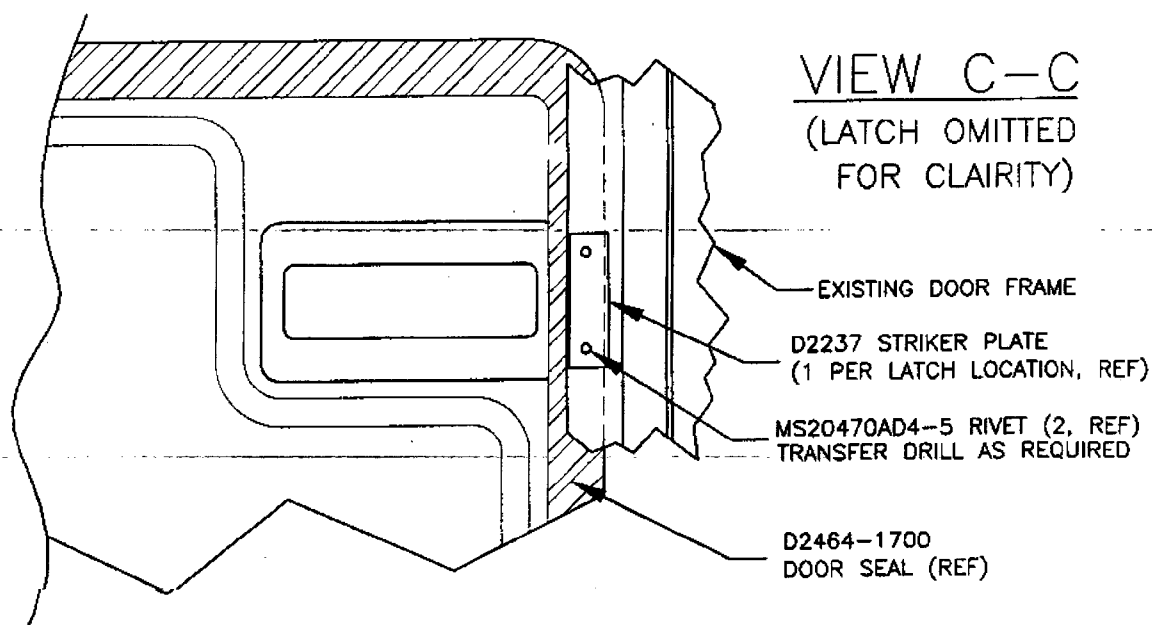
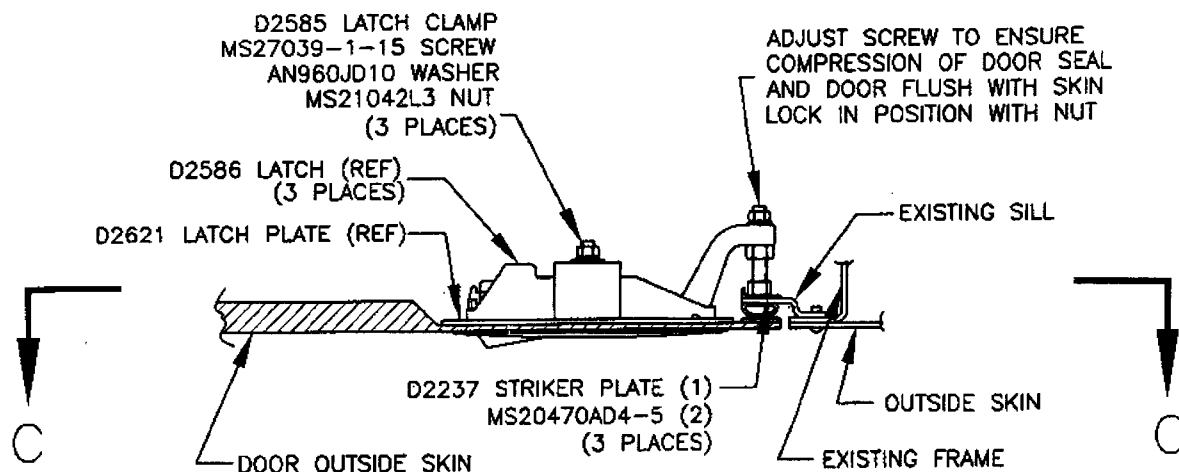


Figure 52-4: Typical Latch Installation

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Chris Provencal

From: Chris Provencal [cprovencal@dartaero.com]
Sent: June 3, 2010 3:36 PM
To: 'David Shepherd'
Cc: 'Mike Petsche'
Subject: FW: NCR D350-589
Attachments: IMG_0152.JPG; IMG_0149.JPG; IMG_0150.JPG; IMG_0151.JPG

David,

Could you respond to this so I can deviate the door (just got verbal OK)? We did the mod and the door fits better. I attached some pics showing the mod.

-Chris

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: May 26, 2010 10:25 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Jason Murdoch'
Subject: NCR D350-589

David,

RE: RH 350 door.

A customer is having issues with his RH door sticking out in the aft-bottom corner (img_1717, img_1715). We sent a replacement door that we tried on our aircraft and it supposedly fit well, but had the same issue with the customer.

Trying on a door that is in production now, you can see that corner does stick out (img_3). The latch is at 3.5" from bottom, pushing in at that location (img_4) does help a lot. Putting the latch at 2.5" from bottom would help even more (img_5).

Do you think that'd be something we would want to implement to reduce the chance of fitting issues?!? That would put the latch further away from the foam and may weaken that area.

I'm thinking we should also have the mold corrected.

-Chris



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

INVOICE

Telephone : (819) 533-5788

Warehouse : MAIN

GST/PST: 867834582RT/1023043731TQ0001

Invoice No.	13106-B
Customer No.	DART

Bill To

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship To

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship Date	Order Date	Our PO #	Order By	Your PO #		GST/PST #	
11/03/2009	13/02/2009	5974	Chantal Lavoie	PO00008193			
Order Ord Qty	Shipped Quantity	Tax	Item Number Item Description		Unit Price	Extended Price	
1	1	TPS	DKC-NRC-AERONAUTIQUE Modification mould D2991-1 As per quote S4-0220		1,500.0000	1,500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE Modification mould D2991-2		1,500.0000	1,500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE Gabarit		0.0000	0.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE Prototype D2991-1 B46674 As per quote S4-0220		500.0000	500.00	
1	1	TPS	DKC-NRC-AERONAUTIQUE Prototype D2991-2 B46680 As per quote S4-0220		500.0000	500.00	
VIA KINGSWAY WB #51280350-6							

Print Date	24/03/2009
Print Time	04:14:45 PM
Page#	1

Total Paid	\$ US 0.00
Balance Due	\$ US 4,200.00

Subtotal	4,000.00
Freight	0.00
Sales Tax	TPS 200.00
Invoice Total	\$ US 4,200.00

Prepared By : JLaurin

Date: Lundi, 2009-03-09 09:53:06
 - Utilisateur: Marc Dubé

DELASTEK
 COMPOSITES INC.
 WWW.DELASTEK.COM

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
 Numéro Job : 43699
 Numéro Soumission : 2644
 Numéro B.A. :
 Cette fois : 2009-03-09 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : -- Type :
 Job précédente :

Nom Dessin : SIDE DOOR N° D2991-2
 Numéro Article : DKC134-0067
 Numéro Dessin : D2991
 Projet Numéro : DKC134
 Révision dessin : D
 Matériel : Composites
 Date Dûe : 2009-03-05

Qté: 1 Udm: UNITE

Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Client: D2991-2



B46680

Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0582 Frekote 700NC N° 38425

Commentair Qty.: 0.025 GALLON(s)/Unit Total : 0.025 GALLON(s)

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0095 selon le QSI-006 et selon IG 0009.

Date: 16/03/09

Sceau:

3.0 AAC0273 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

4.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0250 PINTE(s)/Unit Total : 0.0250 PINTE(s)

5.0 AAC0198 UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 16/03/09

Sceau:

Temps Début: 10:15 Temps Fin: 10:30

Utilisateur: Marc Dubé

Feuille de ProcédéClient: DART Dart Aerospace Ltd.
Numéro Job: 43699Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description:

7.0

GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du Gel coat sur le moule N° DKC-0095 selon IG 0019

Date: 16/04/09 Sceau:



8.0

AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0

AC0407

Wrighton 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0

AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0

AC0752

Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0

AAC0276

Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

13.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

14.0

AC0098

Ruban à gommer jaune # T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 11/04/09 Sceau:



Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43699Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.: Machine ou Opération: Description :

16.0 AAC0274 Derakane 411-350 Promote N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)

17.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0060 UNITE(s)/Unit Total : 0.0060 UNITE(s)

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 16/10/09 Heure Début: 1:10 Heure Fin: 1:15 Sceau:

19.0 LAMINAGE LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 16/10/09 Heure Début: 1:15 Heure Fin: 1:30 Sceau:

20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 16/10/09 Sceau:

Curing début: 1:15 Curing Fin: 8:00

21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.143 KIT(s)

22.0 DKC134-0063 Foam Core N° D2991-102(Porte D2991-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43699Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description:

23.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Assembler le Foam Core DKC134-0063 Selon IG 0033

Date: 17/10/09 Heure Début: 10:15 Heure Fin: 10:30 Sceau:



24.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Date: 17/10/09 Sceau:



Curing Début: 10:15 Curing Fin: 11:45

25.0

AAC0274

Derakane 411-350 Promoté N° RV411B3020

Commentaire Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)

26.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s)

27.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18/10/09 Heure Début: 8:40 Heure Fin: 9:50 Sceau:



28.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 18/10/09 Heure Début: 8:50 Heure Fin: 9:20 Sceau:



Outilsateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 43699

Nom Dessin: SIDE DOOR N° D2991-2

Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description:

29.0

POCHE À VIDE 1.

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 18/09/09 Heure Début: 9:00 Heure Fin: 9:30 Sceau:  

Curing Début: 8:40 Curing Fin: 2:00

30.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 18/09/09 Sceau:  

31.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit N° DKO-0119 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Perçer les " Latch " et les trous de peinture selon le dessin N° D2991.

Date: 18/09/09 Sceau: 

32.0

AAC0433

Hysol 934NA part A&B (quant kit)

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)

33.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s)

34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0119 Perçer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43699Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description:

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 86 et d'une seringue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 18/09 Sceau:



35.0

TRIMAGE

TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit NOKO-0119 Repercer les 3 trous de 1/4" Dia.

Date: 19/09 Sceau:



36.0

AAC0433

Hysol 934NA part A&B (quant kit)

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

37.0

AAC0697

N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

38.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÈCES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 19/09 Sceau:



39.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

40.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)

41.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

Date: Sceau:

Utilisateur: Marc Dubé

Feuille de ProcédéClient: DART Dart Aerospace Ltd.
Numéro Job: 43699Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description:

42.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

43.0

EMBALLAGE

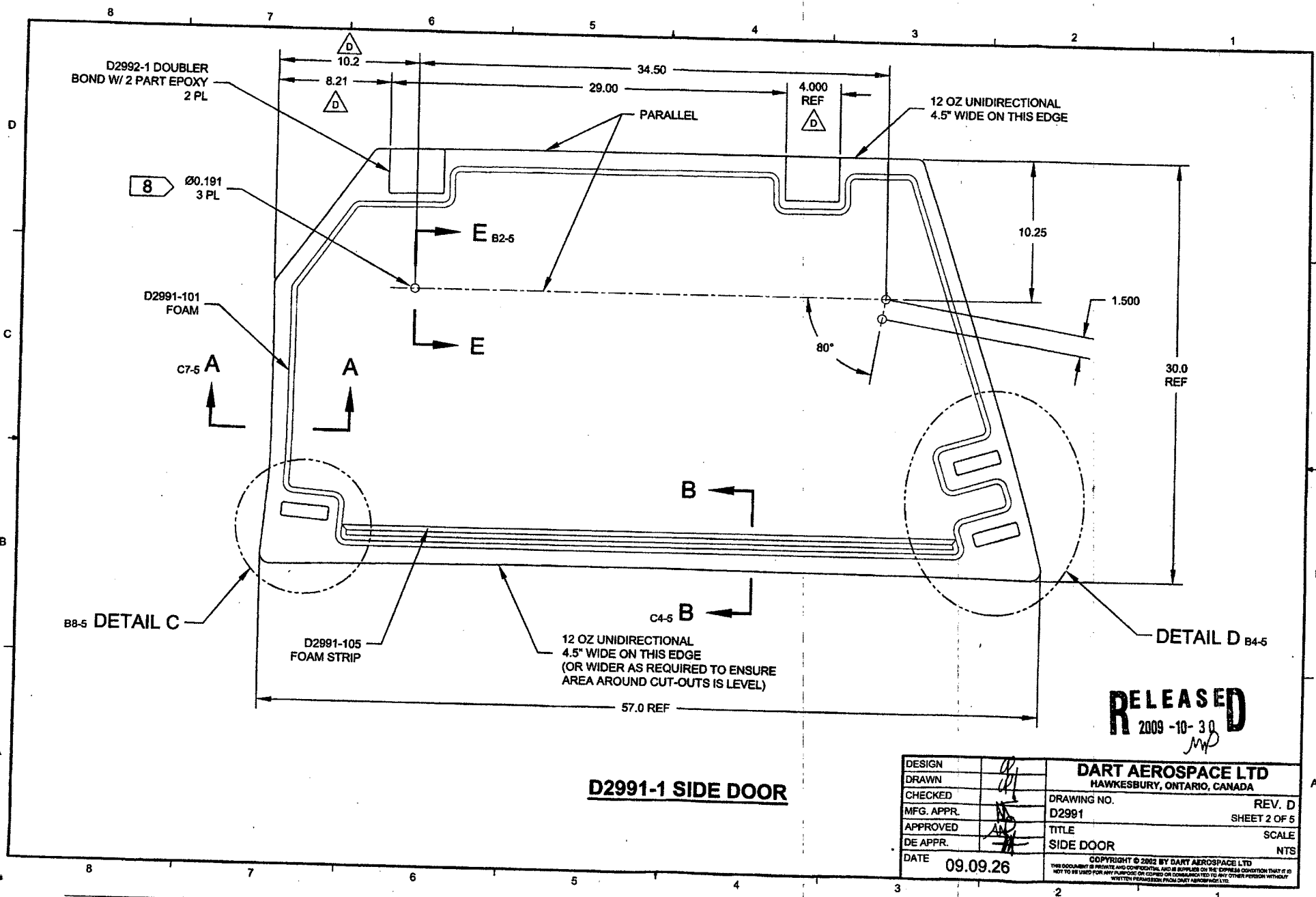
EMBALLAGE ET ENTREPOSAGE

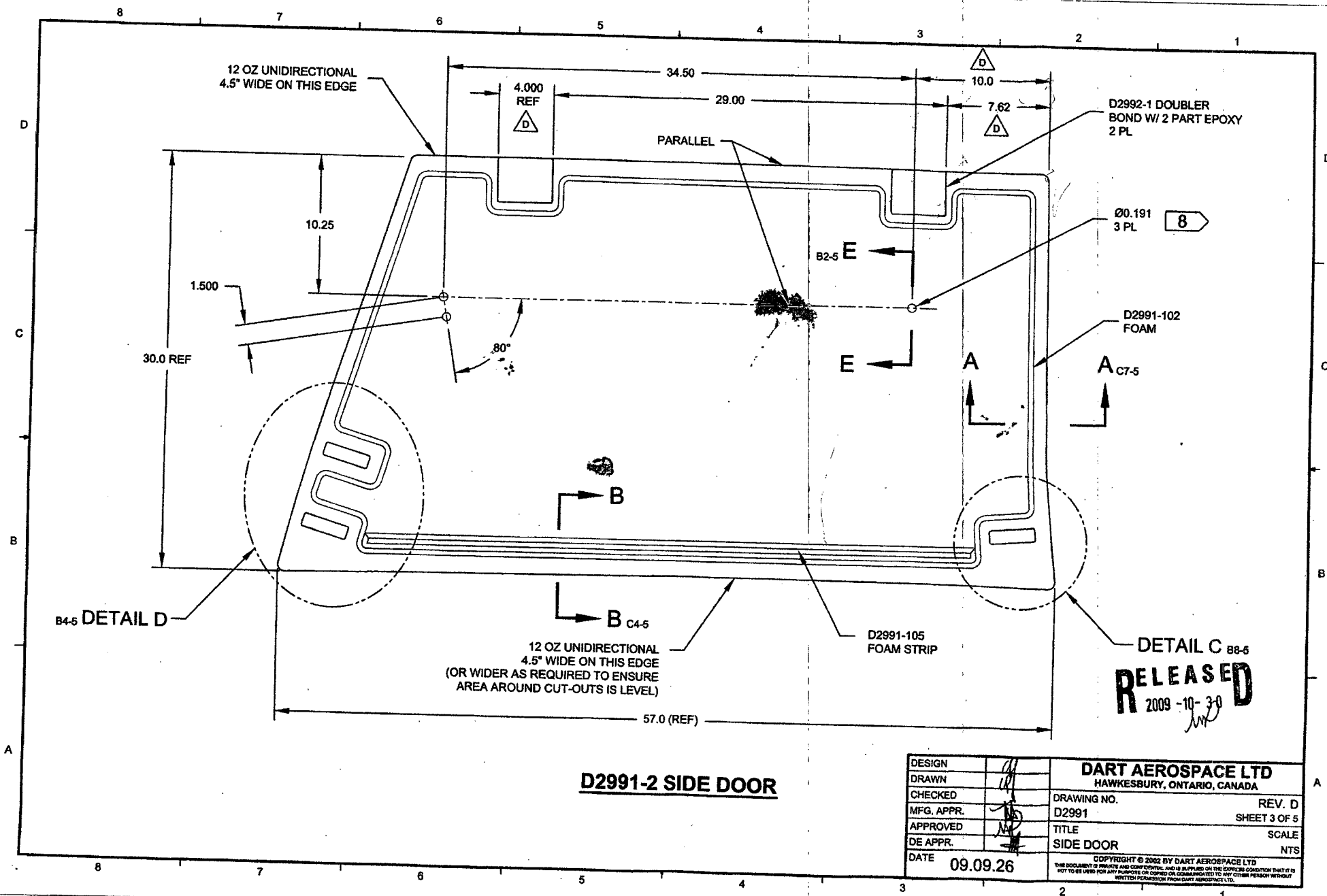


Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: _____ Date: _____ Sceau: _____

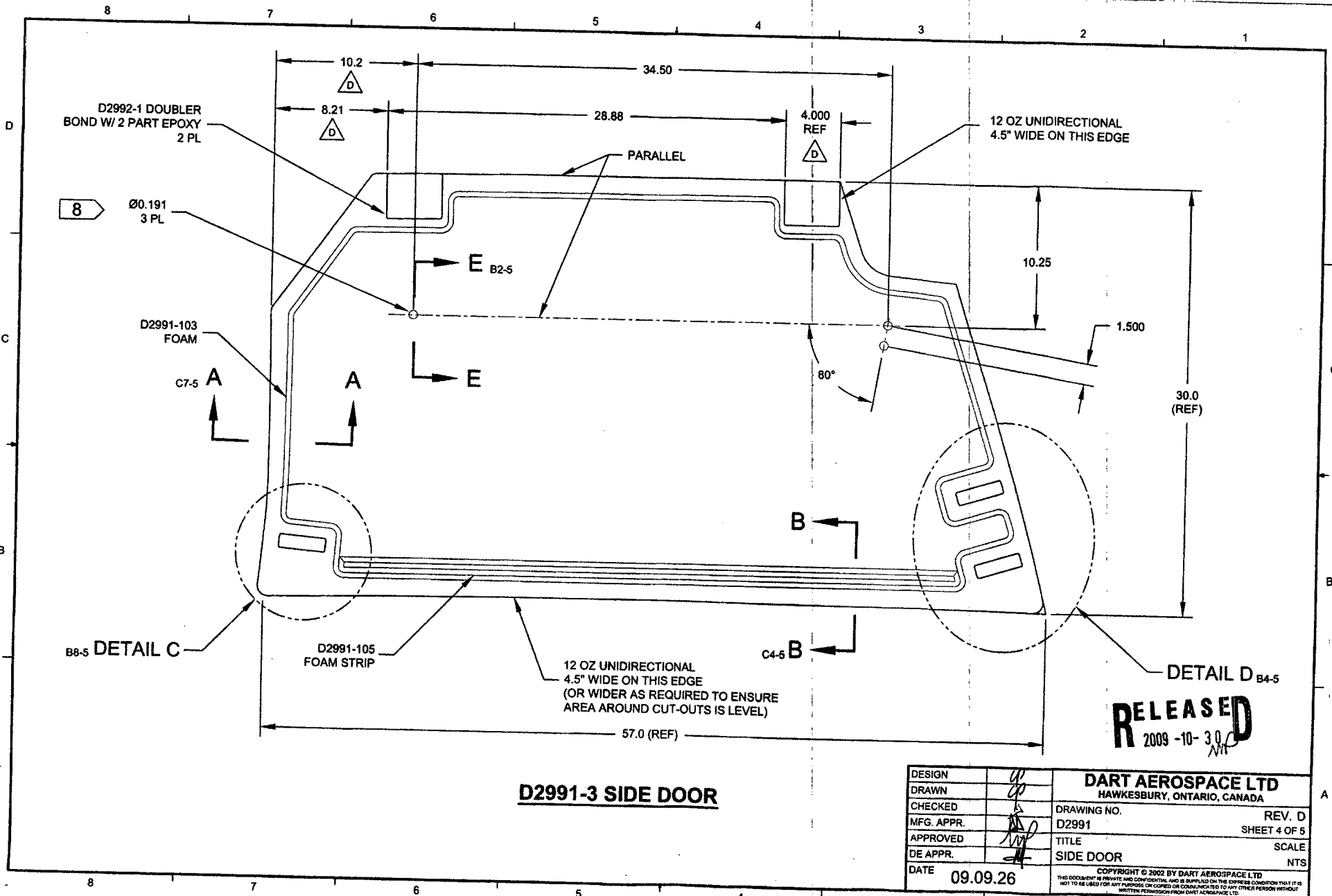


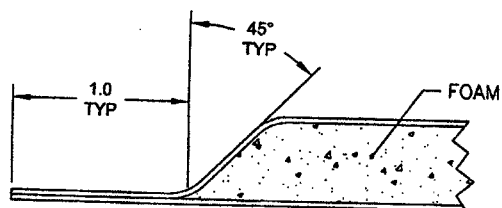


D2991-3 SIDE DOOR

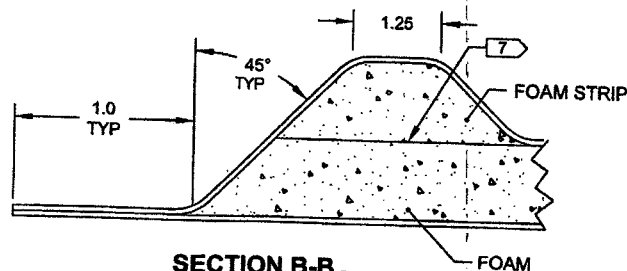
RELEASED
2009-10-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small> COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

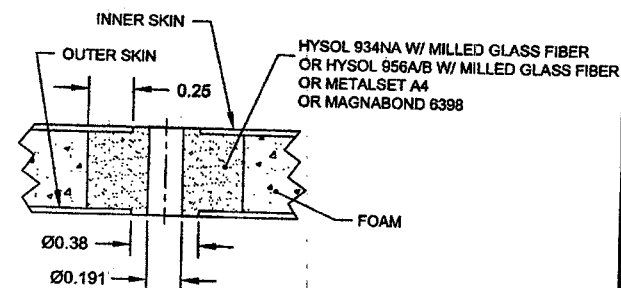




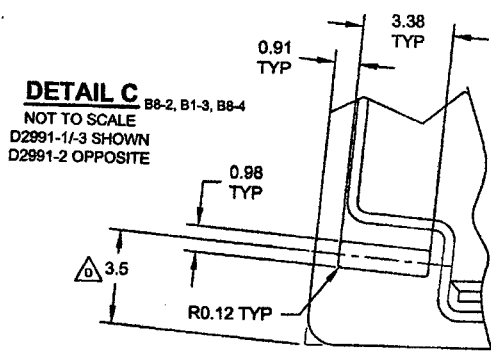
SECTION A-A
NOT TO SCALE
C7-2, C2-3, C7-4
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



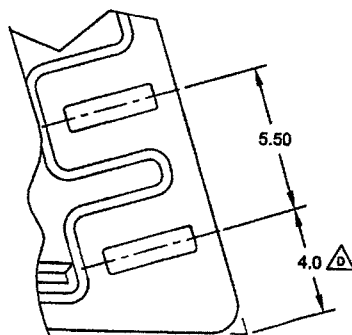
SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
B4-2, B5-3, B4-4
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE
D6-2, D3-3, C6-4



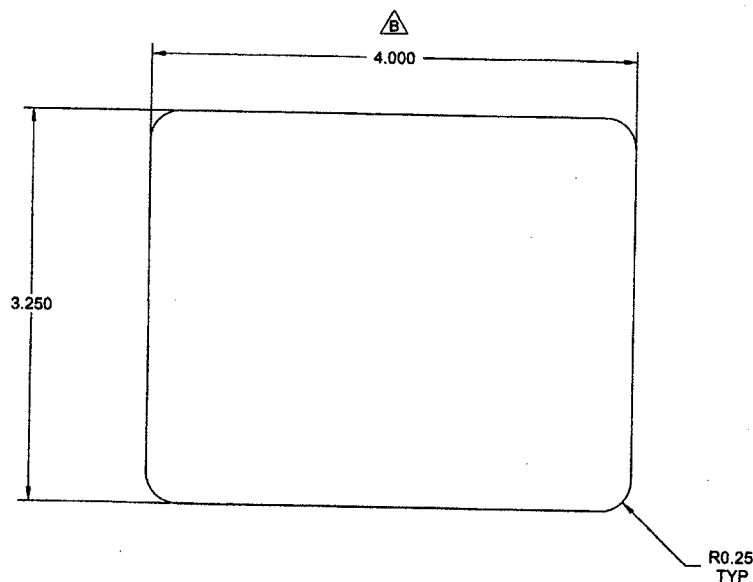
DETAIL C
NOT TO SCALE
B8-2, B1-3, B8-4
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D
NOT TO SCALE
B1-2, B8-3, B1-4
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

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2009-10-30

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2992-1 DOUBLER

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2992-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

RELEASED
2009-10-30

B	REFORMAT DWG, 4.000 WAS 3.250 (ZN D8-1), NCR 09-041	CP	09.09.26
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2992	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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